

Work Order ID 115522

\*115522\*

Page 1

April-02-14 2:55:17 PM

Item ID: D2741

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Blade

Start Date: 4/02/14

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-04-02

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2741

Rev D

100

\*100\*

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks=13.850" long +0.063" -0.000"

DAS  
02  
9-89

ET 14-04-08

110

\*110\*

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA108

DAS  
02  
9-89

ET 14-04-08

120

\*120\*

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

DAS  
02  
9-89

ET 14-04-08

40 0 DA 14-04-10

ATO NRK



Work Order ID 115522

April-02-14 2:55:17 PM

\*115522\*

Page 3

Item ID: D2741

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Blade

Start Date: 4/02/14

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Outsource process - Heat Treat

0.00

\*160\*

Outsource1

Outsource process - Heat Treat

Memo

0.00

Issue P/O: 23814  
Harden material as per Dwg D2741

Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC)

Min. Yield Tensile Strength = 141 ksi

Test report or Certification required

\*\*Sand blast parts\*\*

CL 14/04/15 (40)

170

Receive & Inspect for Damage & Mat'l Certs

0.00

\*170\*

Packaging

Packaging

Memo

0.00

Ensure Test report or Certification attached

14/05/14 40

Work Order ID 115522

April-02-14 2:55:17 PM

\*115522\*

Page 4

Item ID: D2741

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Blade

Start Date: 4/02/14

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

DAS

\*180\*

0.00

M/5/2

QC

Memo

Quality Control

190

0.00

\*190\*

0.00

20 taken for w/o 117791  
D2741-NP

HandFinish

Memo

Hand Finishing

clean with wash &amp; wipe to remove oil

200

0.00

\*200\*

0.00

White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel

M/128027

Powdercoat

Memo

Powder Coating

START TIME: 10:45

OVEN TEMPERATURE: 400°

FINISH TIME: 11:15

20  
H-5-8DAS  
34  
9.89

Work Order ID 115522

April-02-14 2:55:17 PM

\*115522\*

Page 5

Item ID: D2741

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Blade

Start Date: 4/02/14

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC3- Inspect Part Finish

0.00

\*210\*

QC

Memo

0.00

DAS  
16  
9-89

14/05/09

20

Qty

Quality Control

220

Identify as per dwg & Stock Location: ST464

0.00

\*220\*

Packaging

Memo

0.00

20X

DAS  
28  
9-89

MAY 09 2014

Packaging

230

QC21- Final Inspection - Work Order Release

0.00

\*230\*

QC

Memo

0.00

MW

14/05/09

Quality Control

close for 40

ME  
14-5-09

# Picklist Print

April-02-14 2:55:20 PM

Page 1

Work Order ID: 115522

**\*115522\***

Parent Item: D2741

**\*D2741\***

Parent Item Name: Blade

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: D00.11.15Removed P/O turning - in house processEC  
 IPP Rev: E 06-03-20 As Per Rev C JLM  
 IPP Rev: F 06.04.20Added grinding after heat treating EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NB0.500X03.00 0		Purchased	No			100	f	52.3800	1.1541	49			

**\*M4130NB0 500X03 000\***

4130 Bar 0.500 x 3.00

\*\*

DAS  
02  
9-89

14-04-08

Location

Loc Qty

Loc Code

MAT033

52.38

m127068

4.38

m128713

48

X 48

DQA:

Date:

14/05/16

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

14/5/13

Work Order update only ☐

Work Order: <u>115 522</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D2741</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3850</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

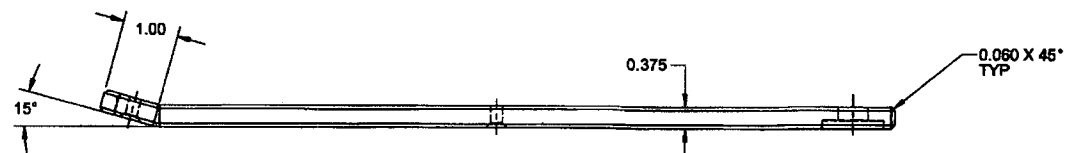
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14-04-10	110	1	MACHINED UNDER SIZED. THE .375 $\pm$ .010	DAS 12 9-89	Acceptable	14-04-11		DAS 27 9-89
Equip/Tooling				15.355	14/4/11	At very end only, won't significantly affect strength or stiffness	DAS 12 9-89	14/04/12	14/4/15
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

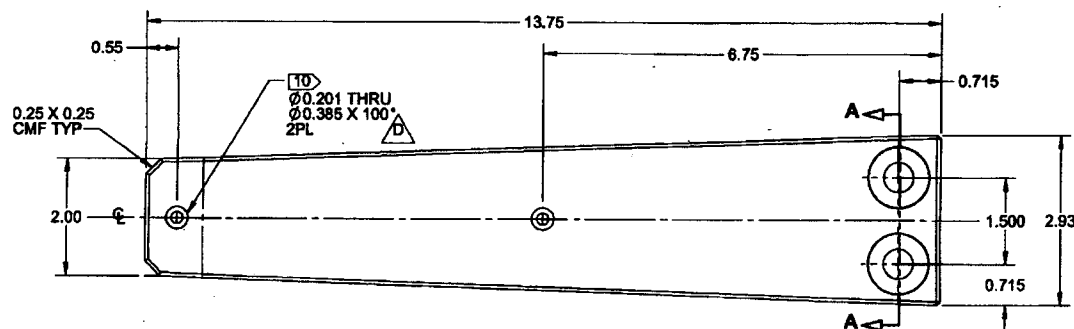
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input checked="" type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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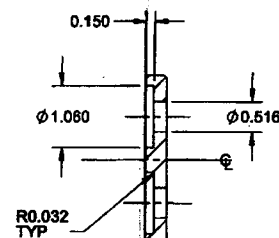




**D2741 BLADE**



**D2741F FLAT PATTERN**



**SECTION A-A**

**RELEASED**  
2013-08-13

**NOTES:**

- 1) MATERIAL: AISI 4130N STEEL BAR PER MIL-S-8758 OR AMS 6345/6348/6370/6528  
REF DART SPEC. M4130N-B0.500X3.000
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: WITH DART P/N "D2741" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 3.3 lbs
- 8) SYMMETRY: ABOUT C
- 9) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 152 ksi AND MIN. YIELD TENSILE STRENGTH = 141 ksi  
PER MIL-S-8758 OR AMS2759/1E AFTER MACHINING.  
ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 34-40 HRC.
- 10) OPTIONAL: ONLY REQUIRED WHEN MAKING D350-636-215/-216/-217/-218

D	ADD Ø 0.201 HOLES AND NOTE 10 (2N 07-1). REMOVE -041/-043 OPTIONS REFORMAT DWG. REF PAR11-72	SFM	13.02.21
C	LARGER HOLE, ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS	PH	06.01.12
B	CHANGE C'SINK TO C'BORE	CP	98.06.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	SFM		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D2741	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BLADE	NTS
DATE	13.02.21	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO23814**

Purchase Order Date 4/15/2014

PO Print Date 4/15/2014

Page Number 1 of 2

Order From  
**METCOR INC.**  
560 BOUL. ARTHUR SAUVE  
SAINT-EUSTACHE, QC J7R 5A8  
CA

VC-MET004

Ship To: **DART AEROSPACE LTD**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Contact Name  
Vendor Phone 450 473 1884  
  
Ship To Contact  
Ship To Phone  
Ship Via: VENDOR'S TRUCK  
Ship Acct:

Buyer Chantal Lavoie  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency CAD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	115522	D2741 BLADE	5/7/2014 Yes 5/7/2014		40.00	\$12.95	\$517.95
HARDEN MATERIAL: ULTIMATE TENSILE STRENGTH = 152 KSI MINIMUM YIELD TENSILE STENGHT = 141 KSI (34-40 HRC) SAND BLAST PART AFTER HEAT TREAT NOTE: DETAIL C OF C REQUIRED							
Line Total:							\$517.95
2	71401-45	PROCUREMENT QUALITY CLAUSES	5/7/2014  No 5/7/2014		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A020 non-destructive test/inspection identification A021 dart aerospace processing A024 process certifications A026 certification of material conformance							

Note:

4/15/2014

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

## Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
195081	1	80900

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON. K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

LIVRÉ À /Shipped To

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON. K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
23814		4130	2014/4/17	CLIENT

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight
40	D2741	BLADE		139,2
	(40) D2741	BLADE		
	REF. 115522			

4 BC EPS

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BC EPS	4	

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40

POIDS EXPÉDIÉ / Weight Shipped : 139,20

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 40

POIDS EXPÉDIÉ / Weight Shipped : 139,20

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2014/04/29



# Metcor Inc.

5601 Route Arthur-Sauvé, St-Eustache (Québec) J8R 5A8  
Tél: 450-473-1884

5601 ROUTE ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8  
Télécopieur/Fax production 450 491-6454

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Rapport d'Inspection

### Inspection Report

BON DE TRAVAIL order	CHARGEMENT load
195081	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
23814		4130		

### SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	40	38.0 - 39.6 HRC
TENSILE (KSI)	152 - 182 KSI		171.0 - 180.0 KSI

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	139.2	D2741 BLADE (40) D2741 BLADE REF. 115522  4 BC EPS

*3040/100*

### COMMENTAIRES / comments

APPROUVÉ par / Approved by:

*[Signature]*



DATE: 2014-04-29

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# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
195081	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
23814		4130		

### SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SEL HARDEN

HARDEN AND TEMPER

SAE AMS 2759/1 REV.E

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	34 - 40 HRC	40	38.0 - 39.6 HRC
TENSILE (KSI)	152 - 182 KSI		171.0 - 180.0 KSI
Tensile values converted from hardness			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	139.2	D2741 BLADE (40) D2741 BLADE REF. 115522  4 BC EPS

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphere	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 PREHEAT 1	1000 +/-25F	1:00 1:30	air			134				
4.00 SEL HARDE	1575 +/-25°F	0:40	sel		Brine	106				
5.00 WASH	150	0:30	soap			121				
6.00 SNAP TEMP	400 +/-10°F	2:00	air			639				

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
195081	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

Operation	Temp. spécifiée Specified Temp	Temps de trempe Spécifié Specified Soak Temp	Atmosphère	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
7.00 SANDBLAS			Sablage							
8.00 DIST INSP										
9.00 TEMPER	875 +/-10°F	4 hrs	air			640				
10.00 HARDN INS										
11.00 SANDBLAS			Sablage							
12.00 HUILAGE			huile	bassin 525						
13.00 FINAL INSP										2014-04-29

### COMMENTAIRES / comments

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec AMS2759.

Le TT a été fait tel que requis par AMS2759 et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec AMS2759 et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of AMS2759.

All HT operations were in compliance with AMS2759 and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with AMS2759 and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

*Vincent Carstensen* (MET 18)

DATE: 2014-04-29

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client./We certify that all the information on this report is exact and in accordance with the order requirements.